

Date: Tuesday, 20/01/2009 2:31:55 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER	
Job Number : 44955		
Estimate Number : 13743		
P.O. Number :	Part Number : D38683	
This Issue : 20/01/2009 S.O. No. :	Drawing Number : D3868 PRELIM	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PRELIM	
Previous Run :	Material :	
Written By : _____	Due Date : 26/01/2009	Qty: 4 Um: Each
Checked & Approved By : _____		
Comment : Est Rev:A 09/01-19 as per prelim issue DD verified by:ec		

POSITIVE
RECALL

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.0125 sf(s)/Unit Total : 0.0500 sf(s)
 6061-T6 .040 Sheet
 batch: 107461 B 9-1-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3868
 Dwg Rev: PRF
 Prog Rev: Lim

B 9-1-21

2-Deburr if necessary

H

M-A

09/01/21

6x

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-1-21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Load 22 (5x)

PTO

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- c'sink holes as per dwg D3868
 2- deburr

FF 09/01/22

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3868-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 02/02/19
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44955</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/22</u>	<u>4.0</u>	<u>EXTRA 4 HOLE ON PART (3 HOLES INSTEAD OF 2)</u>	<u>[Signature]</u> <u>09/01/22</u>	<u>SCRAP + Destroy no replace qty (X)</u>	<u>B</u> <u>9-1-22</u>	<u>S</u> <u>09/01/22</u>	<u>[Signature]</u> <u>09/01/22</u>	<u>S</u> <u>09/01/22</u>

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:31:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44955

Part Number: D38683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
A. PROVAL



Comment: INSPECT WORK TO CURRENT STEP

51
09.01.22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5X
M-H 09/01/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 09.01.27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

D3866-013

B 44953-2

Sh 09/01/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



U 09.01.27

POSITIVE RECALL

EFFECTIVE 09.01.27 AUTH H

RELEASED DATE 09.02.17

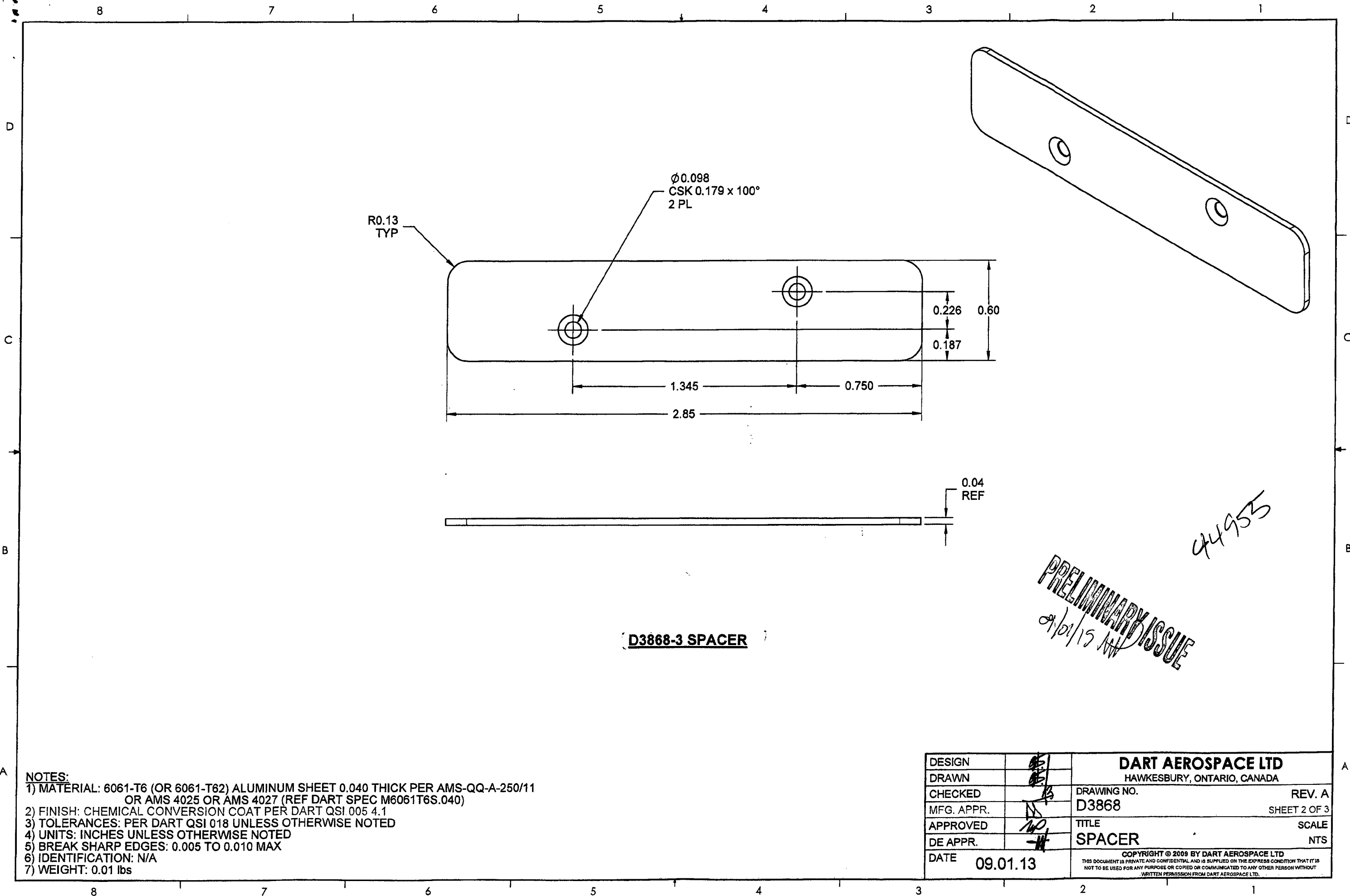
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

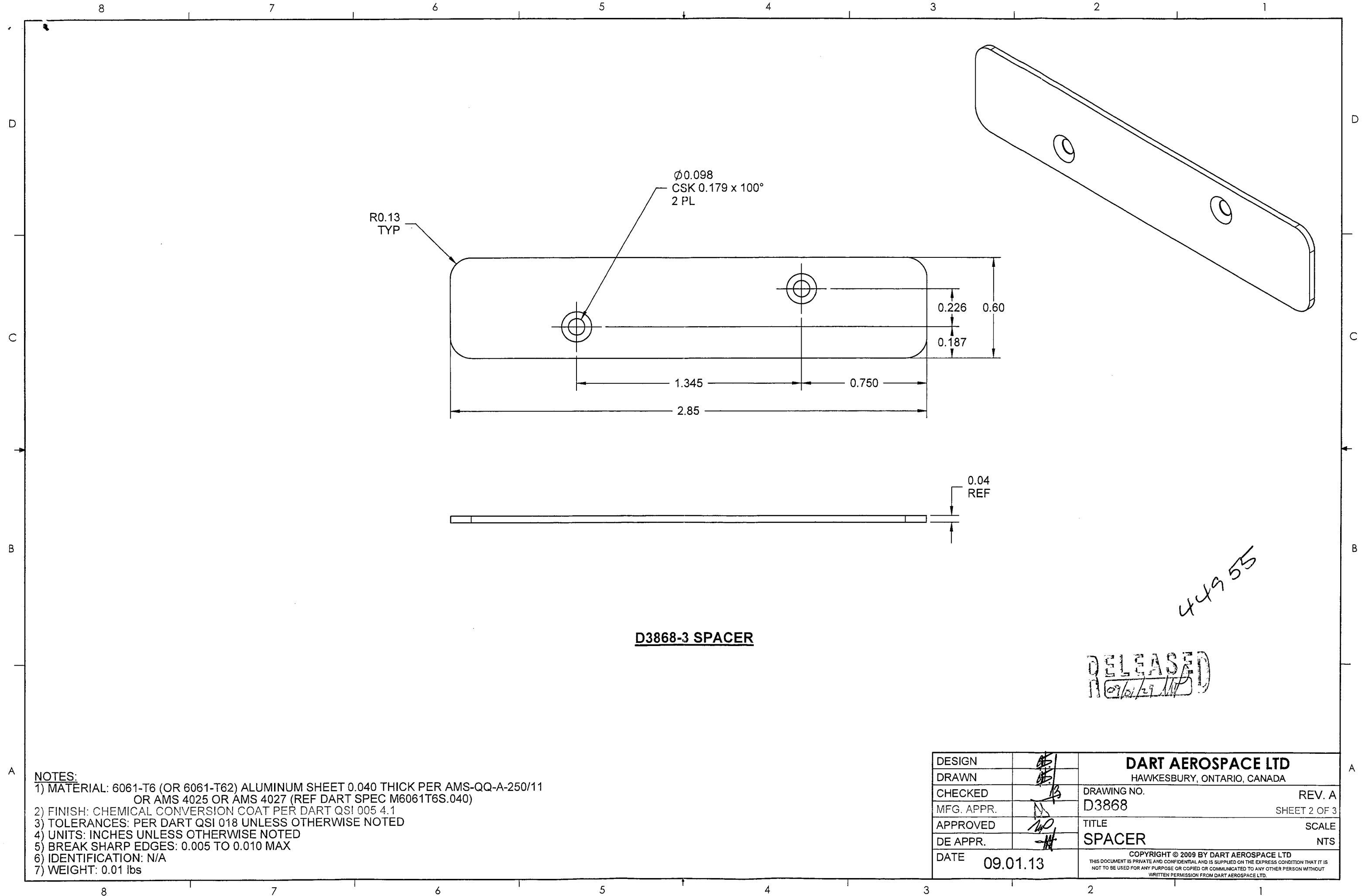
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3868	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	09.01.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	